AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application:

LISTING OF CLAIMS:

Claims 1-20 (Canceled)

21. (Currently Amended) A method of ~~cutting~~ machining a cast iron workpiece, the method comprising:

~~comprising using the insert of claim 9~~

providing a coated cemented carbide body insert, the coated cemented carbide body insert including a cemented carbide body, a first layer adjacent the cemented carbide body, the first layer including Ti(C,N) and having a thickness of from about 3 to about 20 μm, an alumina layer adjacent said first layer, the alumina layer including α-Al_2O_3 and having a thickness of from about 1 to about 15 μm, a further layer adjacent the alumina layer, the further layer including a carbide, carbonitride or carboxynitride of one or more of Ti, Zr and Hf, the further layer having a thickness of from about 1 to 15 μm, and a friction-reducing layer adjacent to the further layer, the friction-reducing layer including one or more of γ-Al_2O_3 and κ-Al_2O_3, wherein the friction-reducing layer has a thickness of from about 1 to about 5 μm;

contacting the coated cemented carbide body insert to the cast iron workpiece; and

removing a portion of the cast iron workpiece in a turning operation.

22. (Currently Amended) A method of ~~cutting~~ machining a steel workpiece, the method comprising:

~~using the insert of claim 9~~

providing a coated cemented carbide body insert, the coated cemented carbide body insert including a cemented carbide body, a first layer adjacent the cemented carbide body, the first layer including Ti(C,N) and having a thickness of from about 3 to about 20 μm, an alumina layer adjacent said first layer, the alumina layer including α-Al_2O_3 and having a thickness of from about 1 to about 15 μm, a further layer adjacent the alumina layer, the further layer including a carbide, carbonitride or carboxynitride of one or more of Ti, Zr and Hf, the further layer having a thickness of from about 1 to 15 μm, and a friction-reducing layer adjacent to the further layer, the friction-reducing layer including one or more of γ-Al_2O_3 and κ-Al_2O_3, wherein the friction-reducing layer has a thickness of from about 1 to about 5 μm;

contacting the coated cemented carbide body insert to the steel workpiece; and

removing a portion of the steel workpiece in a turning operation.

23. (Currently Amended) A method of ~~cutting~~ machining a steel workpiece, the method comprising:

~~using the insert of claim 10~~

providing a coated cemented carbide body insert, the coated cemented carbide body insert including a cemented carbide body, a first layer adjacent the cemented carbide body, the first layer including Ti(C,N) and having a thickness of from about 3 to about 20 μm, an alumina layer adjacent said first layer, the alumina layer including κ-Al_2O_3 and having a thickness of from about 1 to about 15 μm, a further layer adjacent the alumina layer, the further layer including a carbide, carbonitride or carboxynitride of one or more of Ti, Zr and Hf, the further layer having a thickness of from about 1 to 15 μm, and a friction-reducing layer adjacent to the further layer, the friction-reducing layer including one or more of γ-Al_2O_3 and κ-Al_2O_3, wherein the friction-reducing layer has a thickness of from about 1 to about 5 μm;

contacting the coated cemented carbide body insert to the steel workpiece; and

removing a portion of the steel workpiece in a turning operation.

24. (Currently Amended) A method of ~~cutting~~ machining a steel workpiece, the method comprising:

~~using the insert of claim 11~~

providing a coated cemented carbide body insert, the coated cemented carbide body insert including a cemented carbide body, a first layer adjacent the cemented carbide body, the first layer including Ti(C,N) and having a thickness of from about 3 to about 20 μm, an alumina layer adjacent said first layer, the alumina layer including a multilayer of α-Al_2O_3 and κ-Al_2O_3, the multilayer of from about 4 to about 150 layers and having a thickness of from about 1 to about 15 μm, a further layer adjacent the alumina layer, the further layer including a carbide, carbonitride or carboxynitride of one or more of Ti, Zr and Hf, the further layer having a thickness of from about 1 to 15 μm, and a friction-reducing layer adjacent to the further layer, the friction-reducing layer including one or more of γ-Al_2O_3 and κ-Al_2O_3, wherein the friction-reducing layer has a thickness of from about 1 to about 5 μm;

contacting the coated cemented carbide body insert to the steel workpiece; and

removing a portion of the steel workpiece in a turning operation.

25. (Canceled)

26. (New) The method of claim 21, wherein the alumina layer consists essentially of α-Al_2O_3.

27. (New) The method of claim 22, wherein the alumina layer consists essentially of α-Al_2O_3.

28. (New) The method of claim 23, wherein the alumina layer consists essentially of κ-Al_2O_3.